

Date: Monday, 11/21/2005 1:16:27 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number : 24854
Estimate Number : 10832
P.O. Number : N/A Part Number : D29322
This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D2932 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : N/A Material : N/A
Written By : SEE COMMENT BELOW Due Date : 12/21/2005 Qty: 4 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0 x 6.25 X 7.88
Grain Along Long 7.88 Length
Batch No: B 25347

J.L 06.04.17

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr

J.L 06.04.17 (P10)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

J.L 06.04.17 (4)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L 06.04.17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-2 PAR #: N/A Fault Category: Prod / machined ^{PARTS} NCR: (Yes) No DQA: [Signature] Date: 06/04/17
 QA: N/C Closed: [Signature] Date: 06.04.25

NCR: 24854		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-17	2	Chamber tool was too low along the 9 th axis run, and the tool ran in along the bottom of the saddle (view C-C) .040 deep. what I would be too thin when channel gets machined.		Scrap & destroy. Replace as noted below.	J.L. 06-04-17			
06-04-17	2	02932-2 B26371 was made on w/o 02939-2 B26371. See for details.		Add 02932-2 B26371 to replace scrap saddle (above) on this w/o See Attached.	J.L. 06-04-17			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 1:16:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 24854

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Er 06/04/17

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M

06-04-19

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/22

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

AR 06/04/24

4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/24 (4)

Job Completion



UL 06.01.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.124	.125	.124		
B	0.100	0.140		.122	.123	.123	.123		
C	0.100	0.140		.128	.128	.126	.127		
D	0.210	0.230		.224	.220	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.239	.239	.240	.240		
N	0.100	0.140		.117	.118	.114	.116		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.501	.501	.500		
Q	3.715	3.725		3.720	3.719	3.719	3.720		
R	2.470	2.510		2.502	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.629	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.368	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585		1.573	1.573	1.572	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	06.04.17

Audited by:	En
Date:	06/04/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024854	Department Code:	
Project Name	:	D2932-2	Burden Flags	: NNNNNNN
Project For	:	WK551	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2932-2	Invoice Number	:
Description	:	206 Saddle Right side	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-21-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Date:
User:Thursday, 3/23/2006 3:52:24 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 26371

Estimate Number : 10937

P.O. Number :

This Issue : 3/23/2006 S.O. No. :

Prsht Rev. : NC

First Issue : 3/23/2006 Type : MACHINED PARTS

Previous Run : 24961

Written By :

Checked & Approved By :

Comment :

Est: B 00.06.26 New DWG rev (mpp 2069) EC

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Part Number : D29392

Drawing Number : D2939 REV B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 4/10/2006

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: B 24890

J.L 06.04.15

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

J.L 06.04.16 (4)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.L 06.04.16 (4)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L 06.04.16 (4)

5.0

QC8

SECOND CHECK







Comment: SECOND CHECK

J.L 06.04.16 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-17	2	Wrong program run on machine. ID2932-2 was made B#B26371. Operator error, punched in wrong folio #		Fix folio to A D2939-2 B26371. Add D2932-2 B26371 to W/O D2932-2 B24854. Replace saddle	JL 06-04-17	 06-04-17	 06/04/17	 06-04-17

REFERENCE ONLY

NOTE: Date & initial all entries